

Date: Thursday, 6/15/2006 1:50:02 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	27578A					
Estimate Number	10189					
P.O. Number	N/A					
This Issue	6/15/2006	S.O. No.	N/A	Part Number	: D2221	
Prsht Rev.	NC				Drawing Number	: D2221/D2235
First Issue	N/A	Type	LARGE FAB ASSY	Project Number	: N/A	
Previous Run	27577A				Drawing Revision	: F/B1
Written By	Scrip <i>Comment Below</i>			Material	: N/A	
Checked & Approved By	<i>AD 06.06.15</i>			Due Date	: 7/10/2006	
Comment	Est Rev:J 05.09.02			Qty:	1	
	Added D3442-1KJ/JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		4 D3166-1 RIB <i>B21326</i>	<i>PD 06-06-29</i>
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2232-3 Hinge bracket <i>B21527</i>	<i>PD 06-07-03</i>
3.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		4 D2325 Support Gusset <i>B216741</i>	<i>PD 06-07-03</i>
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2327-3 Bushing <i>B21051</i>	<i>PD 06-07-03</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date:
User:

1:50

Process Sheet

Customer: CO-0001

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27578A

Part Number: D2221

Job Number:



Seq. #:	Machine Or Operation:	Description :	
5.0	D2581	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2581 Mounting Bracket <u>B27524</u>	<u>PD</u> <u>06-07-03</u> (1)
6.0	D34421	Shim	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D3442-1 Shim <u>B26739</u>	<u>PD</u> <u>06-07-03</u> (1)
7.0	M304EX07516F	Expanded Metal Flat Stai	
		Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)	
		Pick:	
		Qty Part Number Description Batch	
		36 sf M304EX0.75-16F Expanded Metal <u>M101358</u>	<u>PD</u> <u>06-07-05</u> (1)
8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)	
		Pick:	
		28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing	
		Batch: <u>M101359</u>	
		<u>M100138</u> → 37.76"	<u>PD</u> <u>06-06-29</u>
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235	
		2-Drill hole in D2221-3 as per Dwg D2221	
		3-Deburr	
		4-Remove all markings on material before welding	
		5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required	<u>PD</u> <u>06-07-06</u>

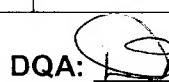
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 

Date: 06/07/04

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/15/2006 1:50:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27578A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DU 06/07/07 ①

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DU SC 06/07/12 ①

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1/06/07-17 ①

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M10193

Expiry date: 11/06

SAU 06:07:13 ①

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DU 06.07.18

Job Completion



DU 06.07.17

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector		
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



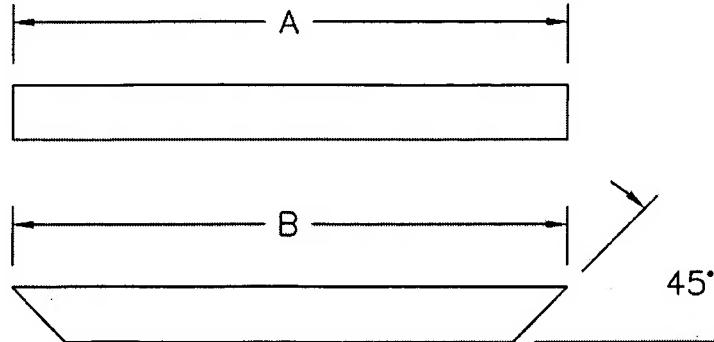
DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED

05.08.19 *[initials]*

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

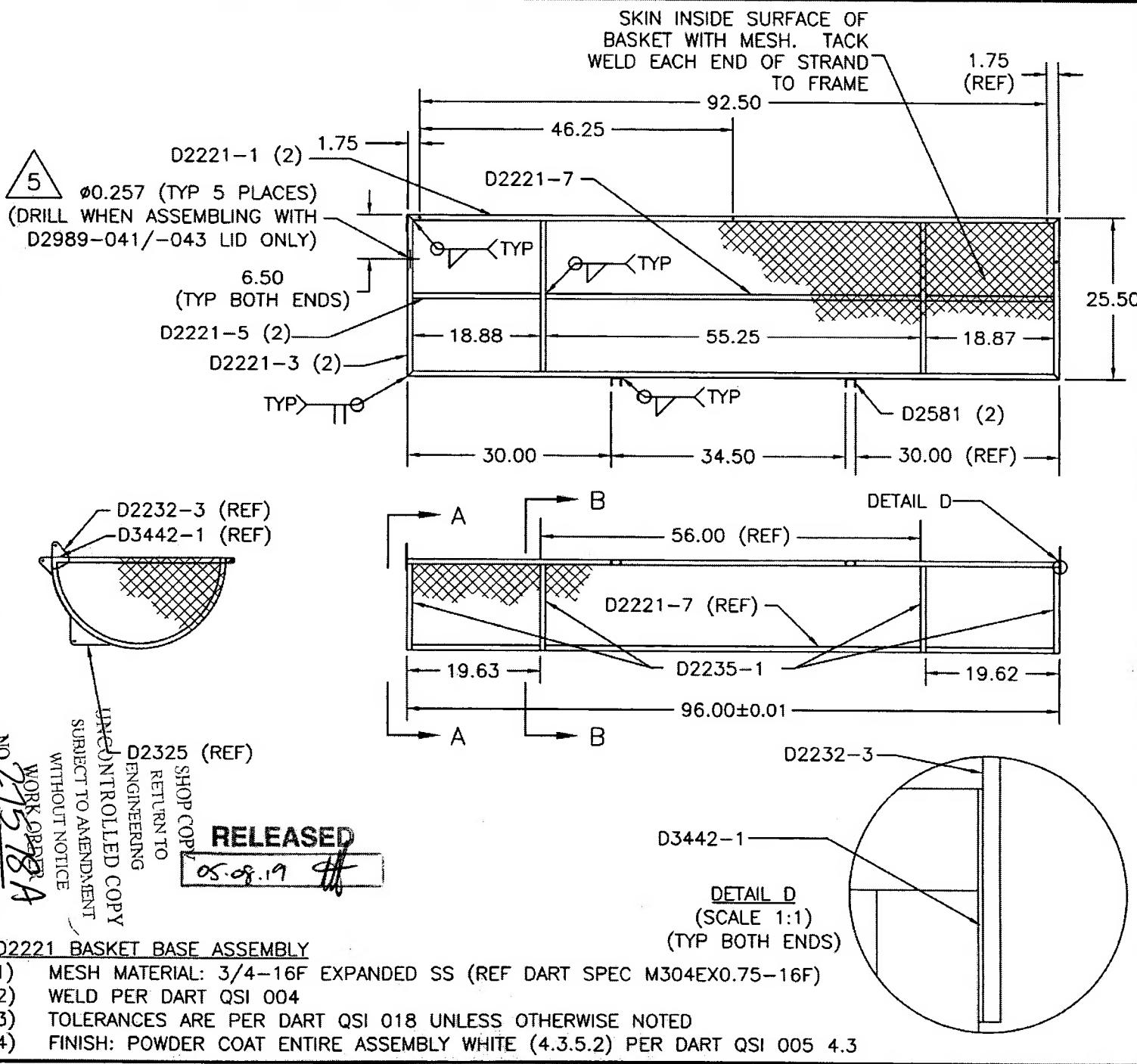
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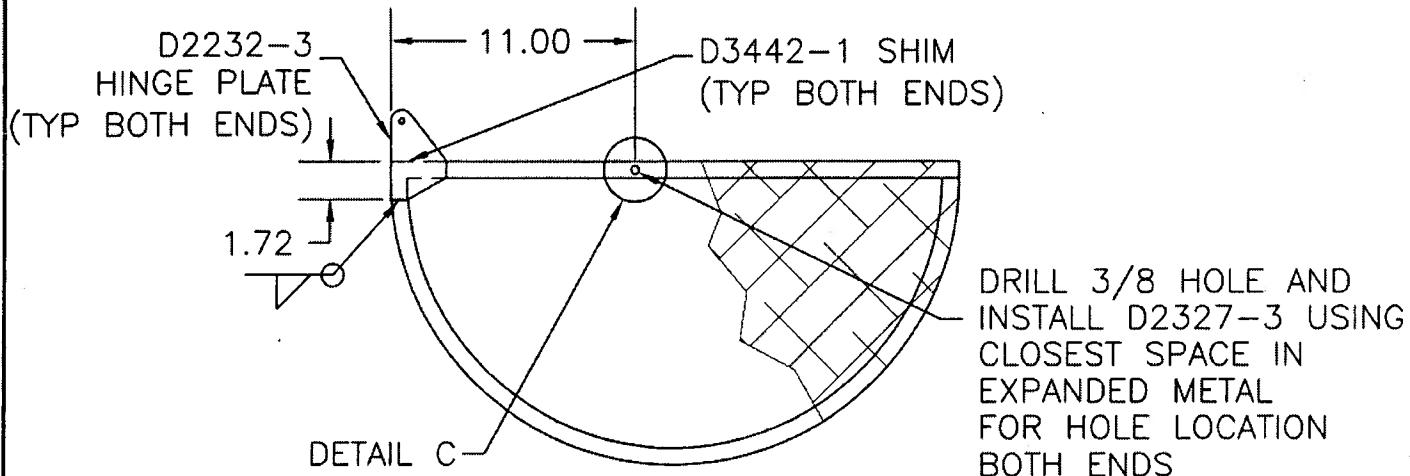
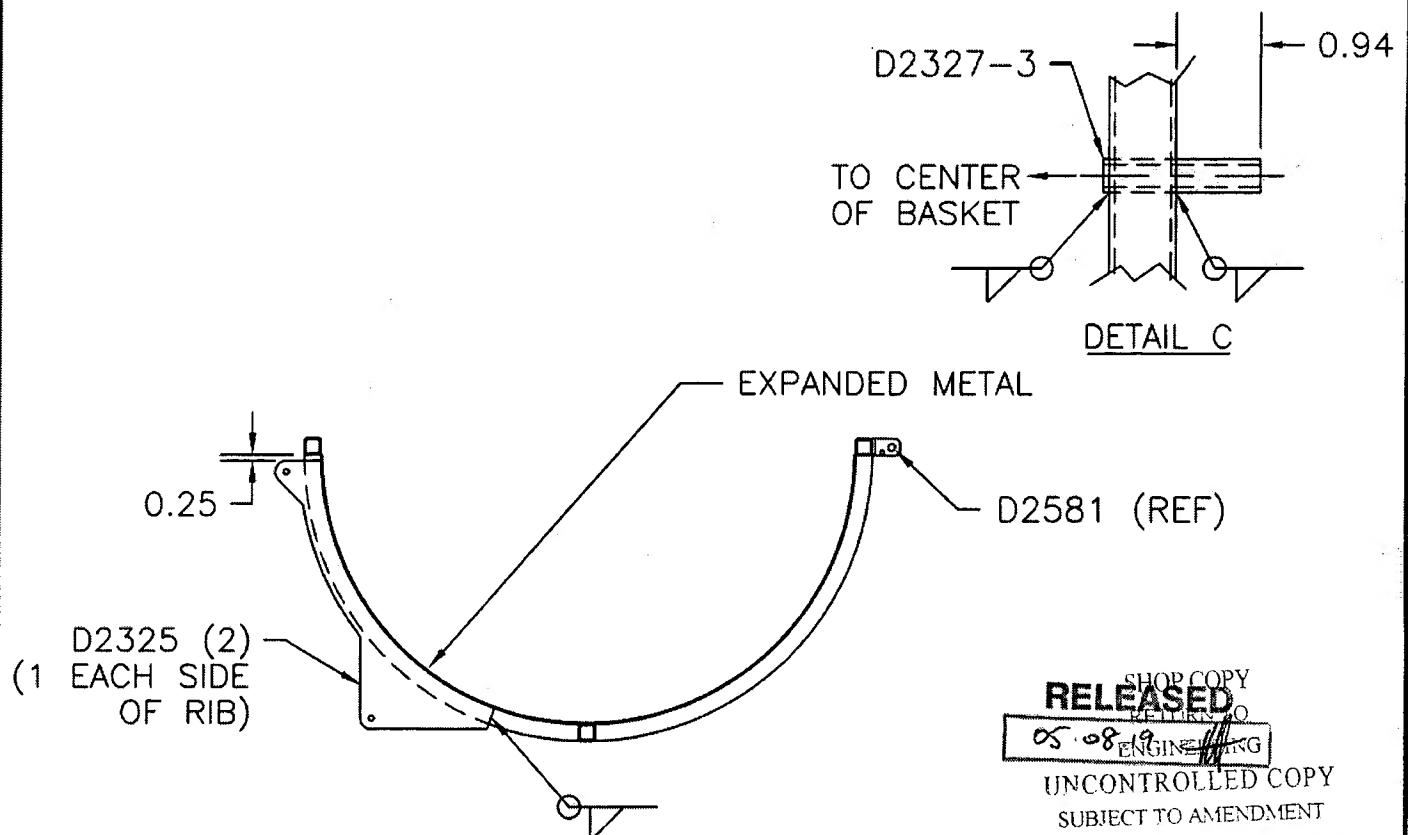
DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	HAWKESBURY, ONTARIO, CANADA	
DATE 05.06.07	DRAWING NO. D2221	TITLE BASKET BASE ASSEMBLY (350)	REV. F SHEET 2 OF 3 SCALE 1:20



DART

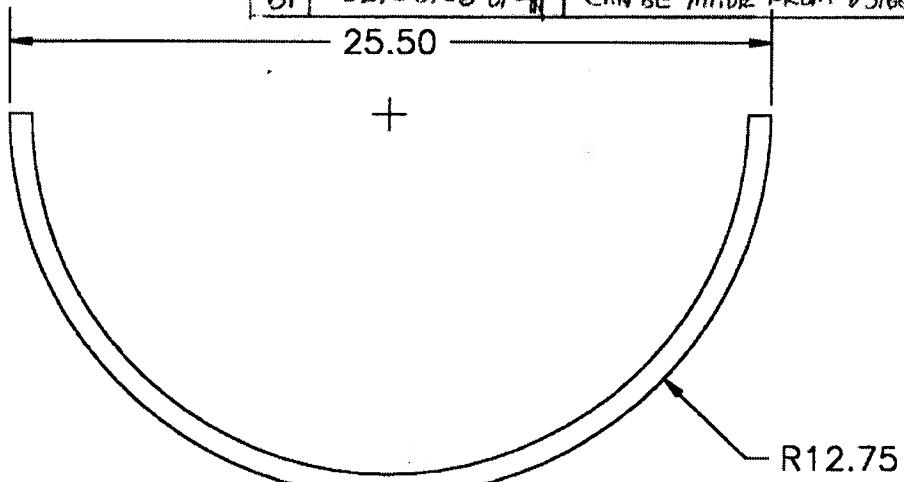
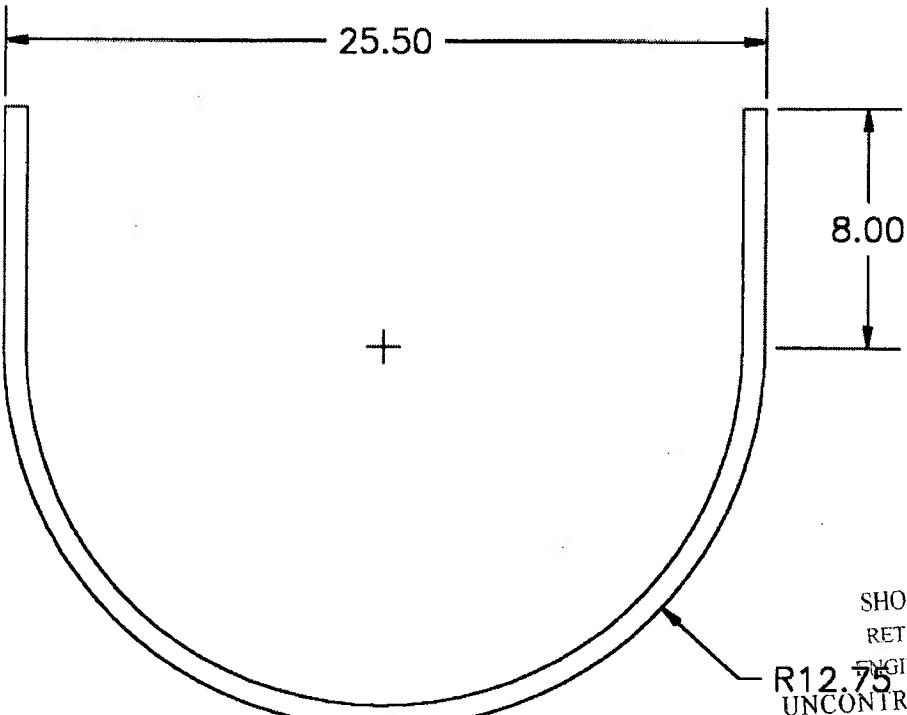
DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
		D2221	SHEET 3 OF 3
DATE		TITLE	SCALE
05.06.07		BASKET BASE ASSEMBLY (350)	1:8

SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

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DART

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE
BI	02, 08, 06 (P)	CAN BE MADE FROM D3166-1	

RELEASED
R 960507D2235-1D2235-3

CAN BE MADE FROM D3166-1 BI
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR. NO 27578A

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